

SOUTH PRODUCTION NOTES

June 5, 2014
Afternoon Shift

BASF EMPLOYEES
90 Last Recordable
340 Last Lost Time

#1 MED / ICL-8:

Continue to make batches after the mixer is fixed/Continue to keep a close eye on diameters. Anything from .129" to .133" is ok but anything higher than .133" will prompt a die change on the extruder. Check the oil in reservoir.

Midnight shift: Mixer valve not repaired yet

Day shift: Valve was taken off of mixer. Still on hold.

Afternoon shift:

#1 RC / ICL-8:

Watch each drum for discoloration (tan) and isolate any of these drums for re feeding. If drum material looks all white, apply label and close. If material is tan, place label on top of drum for refeeding (tape it so it does not get lost).

Feed rate 400-425. We will feed the refeed drums at a reduced temp (drop to 760 degrees) if needed.

Midnight shift: Hold...no material to feed

Day shift: Hold.

Afternoon Shift:

Exhaust to F1 for ICL-8

#2 MED line/ Cu-0860:

Down until we get more 3818. Use the wet mix cart for cleaning out the barrel and add it back into the mixer. Do not create wet mix drums unless we know we have a bad batch of material that needs to be drummed off.

Midnight shift: Out of Cu 3818

Day Shift: Still on hold for 3818.

Afternoon Shift:

#2 RC/ Cu-0860:

Continue per the MOD. Keep the feed rate up on this calciner. It has been too low lately.

Midnight Shift: Continue to feed

Day shift:

Afternoon shift:

Exhaust to F1

#3 MED line / D-0713:

MED is about ready. Still have a few open items/issues (Scale for station 3 in powder room not working properly, scale weight runs up to 2400 #s and then resets to zero regardless what weight bag is hung; pulva chain is missing)

Midnight Shift: Vac-U-Max filters changed out Wednesday, dryer chutes re-cleaned and residual material purged off of dryer belt. However, on hold until items above are addressed.

Day shift: Pulva chain arrived a little past noon. Hope to have it re-installed late on 1st shift. OCS is looking at station 1 issues mentioned above late on 1st shift.

Afternoon Shift:

#3 RC / D-0768 finished, D 0713 next:

All material fed, calciner coming down for reversing and cleaning for D 0713

Midnight shift: Bringing calciner temps down, needs reversed, and then prepped for D 0713 per the cleaning sheet.

Day shift:

Afternoon Shift:

Exhaust to Trimer (out of HEPA filters for CTO)

#4 RC / Cu 0360:

DOWN until 5 hoist is repaired-they are on same circuit. Finished feeding fresh material into 22 gl silver drums. 20 drums (55 gl.) originally filled at 300 lbs. These drums will then be topped off at 400 lbs instead. Labels are printed and ready – Ray's desk. We will feed the bags (1-3) at end of run or when we run out of fresh feed - lower temps to 300.

Midnight Shift: Down-hoist 5 not repaired. When running again, will continue filling black 55 gl drums

Day shift: Down. Hoist should be repaired early on 2nd shift. We have 2 full and a partial bag that were brought down from the North end to feed, then we can reduce the temperatures and feed the 3 contaminated bags at a reduced temperature(see above).

Afternoon Shift:

Exhaust to 4A DC

#5 RC / Cu-3818:

DOWN until 5 Hoist is repaired. We will only use Phibrotech copper and the material will be discharged onto a 120 bag. Feed rate is at 14.0 hz.

Midnight shift: Down – hoist not repaired. Hoist vendor/contractor being contacted, trying to get on site by Thursday.

Day shift: Hoist will hopefully be repaired early on 2nd shift. We can then restart the feed(the bag that was hanging had to be emptied into the hopper before the hoist could be changed out, so we currently have a full hopper).

Afternoon shift:

Exhaust to 5A DC

PK Blender / Na Selexorb Intermediate next:

Waiting for maintenance. Building, day tank and PK have been rinsed. End seal being worked on(6/5/14 M.V.)

Midnight Shift: DOWN/Work order is in for end seal.

Day shift: End seal being worked on.

Afternoon shift:

Old Pfaudler – D-0754:

In addition to the drainage sample we were collecting we must also collect a sample of each batch (8 oz baggy) and a sample of the solution tank. Make sure that all samples are properly labeled. Send to the lab for evaluation – this is a customer request let's make it happen with EVERY batch we make. Make sure that we add on the batch sheet any drainage collected and add to the label of the sample the batch number.

Midnight Shift: Pfaudler full, emptied 2 buggies out of hopper (material flowed OK). Slow go as the calciner quit on midnight shift and cannot keep lit...work notification written for electrical assistance.

Day Shift: No batch made. Waiting for #6 RC to get relit.

Afternoon Shift:

#6 RC / D-0754:

Remember that we are to take a single large sample (not two, just one) per MOD and we need to collect a chemi sample that will be collected only during midnight shift. When running, be sure to:

(1) Get pallet and empty bag weight, write with marker on side of pallet and on check-weigh sheet. On pallet mark it "Tare *** lbs; (2) Fill bag, record net weight on sheet and add to tare weight; (3) Take full bag and pallet to check scale and re-weigh. Record check-weight on sheet and record difference on sheet.

Midnight shift: Calciner quit on midnight shift. Work notification written for electrical assistance. Numerous attempts made to relight but keeps stopping several minutes after maxi's engaged.

Day Shift: Calciner relit with the help of an electrician. Feeding late on 1st shift.

Afternoon shift:

Exhaust to Sly Scrubber

New Pfaudler / Cu 0226-start on Next Tuesday :

Need cleaning instructions

Midnight shift: No activity

Day shift:

Afternoon Shift:

Abbe Blender – D-5206:

We can run on the weekend and off shifts. Make sure to read Grodecki's instructions at the end of the shift notes regarding how to match up lots of 5202.

Midnight shift: No activity as last batches made afternoon shift

Day shift: No change.

Afternoon Shift:

National Dryer / D-5206:

Feed as material becomes available.

Midnight Shift: Feeding as material available

Day shift: No change.

Afternoon Shift:

Tower 3 /Cu-0860 is Next:

Loaded. Started running. Sheaves have been changed

Midnight Shift: Tower unloaded and washed down. When dry (early day shift), reload with Cu 0860

Day shift: Tower was reloaded and fired up with Cu-0860.

Afternoon shift:

Tower 6 / 930 VAM:

Loaded and running. Each tower load will take 5 super sacks filled with 8 drums.

Midnight Shift: Unloaded and reloaded with next 930 VAM

Day shift: Loaded and cooking.

Afternoon shift:

North Screener / DPT-101:

We need to double band all of the socks to the bins **BEFORE OPENING ANY BINS – use the newly acquired adjustable quick disconnect hose clamps.** Make sure that we hit the MOD rate.

Midnight shift: Setting up to screen as tower was unloaded

Day shift: Continued to screen.

Afternoon Shift:

South Screener / Change over to Cu-0860:

We need to double band all of the socks to the bins BEFORE OPENING ANY BINS – we have now in place the newly acquired adjustable quick disconnect hose clamps. Make sure that we hit the rate required.

Midnight shift: Changed over to Cu 0860

Day shift: On hold for first load of Cu 0860.

Afternoon Shift:

#2662 (east) Pill Machine / Zr-0403 1/8: Hold

Started to clean up and take apart machines in preparation for Zr material. We will use only one dust collector.

Midnight shift: No change

Day Shift: No change

Afternoon shift: No change

#2664 (west) Pill Machine / Zr-0403 1/8: Hold

Started to clean up and take apart machines in preparation for Zr material. We will use only one dust collector.

Midnight shift: No change

Day Shift: No change

Afternoon shift: No change

TK #2 V 2046:

All saggars have been changed over to V 2046. The kiln has been lit and is currently up to temperature. We have material to feed so we can start the process. The Dust collector was repaired by maintenance.

Midnight shift: Work order is in to repair hydraulic leak / seal. DC hose was replaced (no work order needed as this is a processor/operator responsibility).

Operator restarted milling to verify level of leakage (hydraulic leak coming from drum dumper, and powder was slowly leaking from milling screw.)

Day Shift: Continued milling after engineer gave the okay on the mill.

Afternoon shift:

At screeners: all totes need to have two bands fastened to sock before opening a new tote.

Work notification to place duct work hangers on the second floor (bldg. 31) – 934147915.

Work notification written to cap / remove ductwork around #3 mixer – 934147916.

Work order to repair hoist for 5 feed hopper.

1. Fines need to be recorded daily on the green sheet.

We are almost done with the D-0768 rework and here is what we have:

Lots 235-237: Good

Lot 238: 4 in wrong supersacks, need repacked

Lot 239: 3 in wrong supersacks, need repacked

Lot 240: 7 in wrong supersacks, need repacked

Lot 241: 9 in correct supersacks, one needs to be topped off by hand

I would like to swap the 9 good supersacks from lot 241 with the 4 wrong ones in 238, 3 wrong ones in 239, and 2 of the wrong ones in 240. That will bring us up to lot 240, supersack 9 of product in the correct supersacks. If agreed, I would like to do this tomorrow (Thursday) morning.

However, we need 4 more supersacks of product in the correct supersacks to complete the order. The ready date on the order is June 13. Can we have the 115's before that date? If so, then we repack the 14 supersacks next week.

Please let me know if you agree.

Thanks,

Bill Grodecki